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WORLD INTELLECTUAL PROPERTY ORGANIZATION  
International BureauDoc Ref. FP39  
Appl. No. 10/728,872

## INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification <sup>7</sup> : <b>B29C 45/27</b>	<b>A1</b>	(11) International Publication Number: <b>WO 00/48814</b> (43) International Publication Date: 24 August 2000 (24.08.00)
<p>(21) International Application Number: PCT/CA00/00142</p> <p>(22) International Filing Date: 15 February 2000 (15.02.00)</p> <p>(30) Priority Data: 2,262,175 16 February 1999 (16.02.99) CA</p> <p>(63) Related by Continuation (CON) or Continuation-in-Part (CIP) to Earlier Application US 09/261,466 (CON) Filed on 24 February 1999 (24.02.99)</p> <p>(71) Applicant (for all designated States except US): MOLD-MASTERS LIMITED [CA/CA]; 233 Armstrong Avenue, Georgetown, Ontario L7G 4X5 (CA).</p> <p>(72) Inventors; and (75) Inventors/Applicants (for US only): GELLERT, Jobst, Ulrich [CA/CA]; 7A Prince Street, Georgetown, Ontario L7G 2X1 (CA). NAKANISHI, Itsuto [CA/CA]; 48 Howland Avenue, Toronto, Ontario M5R 3B3 (CA).</p> <p>(74) Agent: BERESKIN &amp; PARR; 40 King Street West, Toronto, Ontario M5H 3Y2 (CA).</p>		<p>(81) Designated States: AE, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CR, CU, CZ, DE, DK, DM, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, US, UZ, VN, YU, ZA, ZW, ARIPO patent (GH, GM, KE, LS, MW, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).</p> <p>Published With international search report.</p>
(54) Title: INJECTION MOLDING APPARATUS WITH REMOVABLE NOZZLE SEAL		
(57) Abstract		
<p>Injection molding apparatus having a removable nozzle seal (110) which screws onto the outside of the front end (76) of a heated nozzle (12). A mounting sleeve (98) having a threaded outer surface (104) is integrally mounted around the front end (76) of the nozzle (12). The nozzle seal (110) has a retaining portion (118) with a threaded inner surface (120) to screw onto the mounting sleeve (98) extending rearwardly from a central nut portion (112). A sealing and alignment flange portion (122) extends forwardly from the central nut portion (112) and fits into a cylindrical portion (124) of a well (14) in the mold (18) to accurately align the front end (76) of the nozzle (12) and prevent melt leakage between the heated nozzle (12) and the surrounding cooled mold (18). In another embodiment, a sealing and alignment portion (136) of the nozzle seal (110) extending forwardly into an opening (148) in the mold (18) forms the gate (90).</p>		
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**Title: Injection Molding Apparatus with Removable Nozzle Seal****BACKGROUND OF THE INVENTION**

This invention relates generally to hot runner injection molding and more particularly to injection molding apparatus having a removable nozzle seal which screws onto the outside of the front end of the heated  
5 nozzle.

Nozzle seals bridging the insulative air space between the heated nozzle and the surrounding cooled mold are well known. U.S. Patent No. 4,793,795 to Schmidt et al. which issued December 27, 1988 shows a gate insert which screws into place and U.S. Patent No. 5,028,227 to Gellert et al.  
10 which issued July 2, 1991 shows a gate insert which slides into place. U.S. Patent No. 5,299,928 to Gellert which issued April 5, 1994 shows a two-piece nozzle seal which screws into place. U.S. Patent No. 5,849,343 to Gellert et al. which issued December 15, 1998 shows another type of gate insert which screws into place. While these previous nozzle seals and gate inserts are  
15 suitable for many applications, they all have the disadvantage that they are seated in an opening on the inside of the nozzle. This limits the size of any insert or liner seated in the front end of the nozzle which, in turn, restricts the strength and thermal conductivity from the heating element to the gate. The ones that screw in have the further disadvantage that location of the  
20 front end of the nozzle is not accurate enough for some applications.

It is also known to provide a sealing ring extending around the outside of the nozzle. For instance, U.S. Patent No. 5,795,599 to Gellert which issued August 18, 1998 shows a nozzle guide and sealing ring mounted around the outside of the front end of the nozzle.

**25 SUMMARY OF THE INVENTION**

Accordingly, it is an object of the present invention to at least partially overcome the disadvantages of the prior art by providing a removable nozzle seal which screws onto the outside of the front end of a

heated nozzle.

To this end, in one of its aspects, the invention provides an injection molding apparatus having one or more heated nozzles extending forwardly into a well in a cooled mold in alignment with a gate leading to a cavity.

- 5 There is an insulative air space extending between the heated nozzle and the surrounding cooled mold. The heated nozzle has a rear end, a front end, and a portion adjacent the front end with a generally cylindrical outer surface. It has a melt bore extending forwardly therethrough from the rear end and an insert extending forwardly from a recessed seat in the front end
- 10 of the at least one heated nozzle. The insert has a rear end and a melt bore extending forwardly therethrough from an inlet at the rear end aligned with the melt bore through the nozzle. A mounting sleeve is integrally mounted around the cylindrical outer surface of the portion adjacent the front end of the heated nozzle and the mounting sleeve has a threaded
- 15 outer surface. A hollow removable nozzle seal has a central portion, a retaining portion extending rearwardly from the central portion, and a sealing and alignment flange portion extending forwardly from the central portion. The retaining rear portion has a threaded inner surface to removably screw onto the threaded outer surface of the mounting sleeve.
- 20 The forwardly extending sealing and alignment flange portion fits into a cylindrical portion of the well in the mold extending adjacent the gate to align the front end of the heated nozzle with the gate and prevent leakage of melt into the insulative air space between the heated nozzle and the surrounding cooled mold.

- 25 In another of its aspects, the invention provides injection molding apparatus having one or more heated nozzles extending forwardly into an opening in a cooled mold extending to a cavity. There is an insulative air space extending between the heated nozzle and the surrounding cooled mold. The heated nozzle has a rear end, a front end, a portion adjacent the
- 30 front end with a generally cylindrical outer surface. It has a melt bore extending forwardly therethrough from the rear end. A mounting sleeve is

integrally mounted around the cylindrical outer surface of the portion adjacent the front end of the heated nozzle. The mounting sleeve has a threaded outer surface. A removable nozzle seal has a front end, a central portion, a hollow retaining portion, extending rearwardly from the central portion, and a sealing and locating portion extending forwardly from the central portion. The central portion and the forwardly extending sealing and locating portion has a melt bore extending therethrough in alignment with the melt bore in the heated nozzle and leading to a gate at the front end of the nozzle seal. The retaining rear portion has a threaded inner surface to removably screw onto the threaded outer surface of the mounting sleeve. The forwardly extending sealing and locating portion fits into a cylindrical portion of the opening in the mold extending to the cavity to locate the front end of the heated nozzle and prevent leakage of melt into the insulative air space between the heated nozzle and the surrounding cooled mold.

Further objects and advantages of the invention will appear from the following description taken together with the accompanying drawings.

#### **BRIEF DESCRIPTION OF THE DRAWINGS**

Figure 1 is a sectional view of a portion of a multi-cavity injection molding apparatus or system having a heated nozzle with a nozzle seal screwed onto the outside of its front end,

Figure 2 is an exploded isometric view showing the front end of the nozzle with the mounting sleeve in place and the nozzle seal seen in Figure 1,

Figure 3 is a bottom view of the front end of a nozzle having a nozzle seal according to another embodiment of the invention,

Figure 4 is a sectional view along line 4-4 in Figure 3, and

Figure 5 is a sectional view of the front end of a nozzle having a nozzle seal according to a further embodiment of the invention.

### DETAILED DESCRIPTION OF THE INVENTION

Reference is first made to Figures 1 and 2 which show a portion of a multi-cavity injection molding system or apparatus having a melt distribution manifold 10 interconnecting several heated nozzles 12. Each nozzle 12 is seated in a well 14 having a generally cylindrical wall 16 in a mold 18. While the mold 18 usually has a greater number of plates depending upon the application, in this case, only a back plate 20, a manifold plate 22, a cavity insert 26 seated in a cavity plate 28, and a core plate 30 are shown for ease of illustration. The melt distribution manifold 10 is heated by an integral electrical heating element 32 and the mold 18 is cooled by pumping cooling water through cooling conduits 34. The melt distribution manifold 10 is mounted between the manifold plate 22 and the back plate 20 by a central locating ring 36 and a number of insulative spacers 38 to provide an insulative air space 40 between the heated manifold 10 and the surrounding cooled mold 18.

The rear end 42 of each nozzle 12 is secured by screws 44 against the front face 46 of the melt distribution manifold 10. Each nozzle 12 has an integral electrical heating element 48 with a terminal 50 and a helical portion 52 extending around a central melt bore 54. An outer collar 56 at the rear end 42 of each nozzle 12 has a forwardly extending flange portion 58 which sits on a circular seat 60 in the mold 18 to locate the rear end 42 of the heated nozzle 12 and provide an insulative air space 62 between the heated nozzle 12 and the surrounding cooled mold 18.

A melt passage 64 extends from a central inlet 66 in a cylindrical inlet portion 68 of the melt distribution manifold 10 and branches outwardly in the melt distribution manifold 10 to convey melt to the central melt bore 54 in each heated nozzle 12. In this embodiment, the heated nozzle 12 has a tip insert 70 with a pointed front tip 72 shrunk fit into a cylindrical seat 74 in the front end 76 of the heated nozzle 12. The heated nozzle 12 is made of steel and the tip insert 70 is made of a material such as beryllium copper or tungsten carbide copper having a combination of thermal conductivity and

wear and corrosion resistance suitable for the material being molded. The tip insert 70 has a rear end 78 and a conical outer surface 80 extending forwardly to the tip 72. It has a melt bore 82 with a slightly tapered central rear portion 84 which splits into two front portions 86 extending diagonally outward from the rear portion 84 to the outer conical surface 80. As can be seen, the rear portion 84 of the melt bore 82 extends through the tip insert 70 from an inlet 87 at the rear end 78 in alignment with the central melt bore 54 extending through the nozzle 12. The melt from the melt passage 64 flows through the melt bore 54 in each nozzle 12 and the melt bore 82 in the tip insert 70 into a space 88 around the conical surface 80 of the tip insert 70 and through the gate 90 into the cavity 92. As seen in Figure 2, in this embodiment, the two front portions 86 are slightly offset from the center of the tip insert 70 to impart a swirling motion to the melt flowing through the gate 90. Although two diagonal front portions 86 of the melt bore 82 are shown, in other embodiments there can be only one or more than two.

The heated nozzle 12 has a front portion 94 adjacent its front end 76 with a cylindrical outer surface 96. As best seen in Figure 2, a mounting sleeve 98 having a larger diameter rear portion 100 and a front portion 102 with a threaded outer surface 104 according to the invention extends around the front portion 94 of the nozzle 12. The mounting sleeve 98 is made of hot work tool steel and is integrally brazed in place at the same time the electrical heating element 48 is integrally brazed in place in a vacuum furnace. In addition to providing the threaded outer surface 104, the mounting sleeve 98 provides the heated nozzle 12 with additional bursting or hoop strength and a larger heat sink. As can be seen, the rear portion 100 of the mounting sleeve has a rearwardly open hole 106 therein into which a thermocouple element 108 extends to control the operating temperature.

A hollow removable nozzle seal 110 is mounted on the front end 76 of the nozzle 12. In this embodiment, the nozzle seal 110 is hollow and is made of a suitable wear and corrosion resistant material such as stainless or H-13 tool steel. The nozzle seal 110 has a central nut portion 112 with an

outer surface 114 with an even number of outer facets 116 such as the double hex shown to be engaged by a wrench (not shown) to tighten and remove the nozzle seal 110. The central nut portion 112 has an insulation groove 117 to reduce heat loss to the cooled mold 18. In other  
5 embodiments, the nozzle seal 110 can be made to be engaged by a different type of tool. The hollow nozzle seal 110 has a cylindrical retaining portion 118 extending rearwardly from the central nut portion 112. The retaining rear portion 118 has a threaded inner surface 120 which fits around the threaded outer surface 104 of the mounting sleeve 98.

10 The nozzle seal 110 also has a cylindrical sealing and alignment flange portion 122 extending forwardly from the central nut portion 112. The forwardly extending sealing and alignment flange portion 122 is made to fit into a cylindrical portion 124 of the well 14 in the mold 18 extending adjacent the gate 90 to align the front tip 72 of the tip insert 70 with the gate  
15 90 and to provide a seal to prevent leakage of the melt into the insulative air space 62 between the heated nozzle 12 and the surrounding cooled mold 18.

The central nut portion 112 of the nozzle seal 110 has an opening 126 therethrough with a tapered inner surface 128. The tapered inner surface  
20 128 of the opening 126 is made to fit with very close tolerances around a matching outer surface 130 extending around the tip insert 70 which is tapered inwardly towards the front to retain the tip insert 70 in place in the cylindrical seat 74 in the heated nozzle 12 and to very accurately locate the front end 76 of the heated nozzle 12 with the front tip 72 aligned with the  
25 gate 90. In another embodiment, the surfaces 128, 130 can have straight and shoulder portions to retain the tip insert 70 in place and to locate the front end of the heated nozzle 12.

Thus, while the threaded rear portion 118 retains the nozzle seal 110, it is the tapered surfaces 128, 130 and the sealing and alignment flange  
30 portion 122 which locate the front end 76 of the heated nozzle 12 with the front tip 72 of the tip insert 70 aligned with the gate 90. As these surfaces are



not threaded, the location is much more accurate than relying on threaded surfaces. Another advantage of the nozzle seal 110 screwing onto the outside of the heated nozzle 12 rather than the inside, is that it allows the tip insert 70 which is made of a more conductive material to be larger. This increased size provides a larger heat sink and brings the more conductive material into closer proximity to the electrical heating element 48 and provides increased and more uniform heat to the front tip 72 which reduces cycle time. Furthermore, the nozzle seal 110 itself as well as the mounting sleeve 98 being in tension provides additional bursting or hoop strength.

10 In use, the apparatus is first installed as shown in Figure 1 and described above. Electrical power is then applied to the heating element 32 in the melt distribution manifold 10 and to the heating elements 48 in each of the nozzles 12 to heat them to a predetermined operating temperature. Pressurized melt is applied from a molding machine (not shown) to the central inlet 66 of the melt passage 64 to provide hot tip gating according to a predetermined injection cycle. The melt flows through the melt distribution manifold 10, the melt bores 54, 82 in the heated nozzles 12 and the tip inserts 70, and through the gates 90 into the cavities 92. After the cavities 92 are filled and a suitable packing and cooling period has expired, 20 the injection pressure is released and the melt conveying system is decompressed to avoid stringing through the open gates 90. The mold 18 is then opened to eject the molded products. After ejection, the mold 18 is closed and the cycle is repeated continuously with the cycle time dependent upon the size of the cavities 92 and the type of material being molded.

25 Reference is now made to Figures 3 and 4 which show a nozzle seal 110 according to another embodiment of the invention. This embodiment is the same as the embodiment described above except that the inner surface 128 of the opening 126 through the central nut portion 112 of the nozzle seal 110 and the matching outer surface 130 of the tip insert 70 are straight rather than tapered. In this embodiment, the tip insert 70 is integrally brazed into 30 place in the cylindrical seat 74 in the front end 76 of the heated nozzle 12

and the taper is not required to retain it in place.

Reference is now also made to Figure 5 which shows a nozzle seal 132 (which is also a gate insert) according to another embodiment of the invention having a valve pin 133 for valve gating. Some of the elements of this embodiment are the same as described above, and elements common to both embodiments are described and illustrated using the same reference numbers. In this embodiment, the nozzle seal 132 similarly has the hollow cylindrical retaining portion 118 extending rearwardly from a central nut portion 134. The rearwardly extending retaining portion 118 also has the threaded inner surface 120 which screws onto the threaded outer surface 104 of the mounting sleeve 98 which is brazed in place around the front portion 94 of the heated nozzle 12 as described above. However, in this embodiment, the central nut portion 134 and a sealing and locating portion 136 extending forwardly therefrom have a melt bore 138 extending therethrough in alignment with the melt bore 54 in the heated nozzle 12 and leading to a gate 140 at the front end 142 of the nozzle seal 132. The sealing and locating portion 136 of the nozzle seal 132 has a cylindrical outer surface 144 which is made to fit into a cylindrical opening 148 in the mold 18 extending to the cavity 92 to locate the front end 76 of the heated nozzle 12 and prevent leakage of melt into the insulative air space 62 between the heated nozzle 12 and the surrounding cooled mold 18. The central nut portion 134 also has an outer surface 114 with facets 116 to be engaged by a wrench. The use of this embodiment is the same as described above.

While the description of the injection molding apparatus having a removable nozzle seal which screws onto the outside of the front end of a heated nozzle has been given with respect to preferred embodiments, it will be evident that various other modifications are possible without departing from the scope of the invention as understood by those skilled in the art and as provided in the following claims.

**I/WE CLAIM:**

The embodiments of the invention in which an exclusive property or privilege is claimed is defined as follows:

1. In an injection molding apparatus having at least one heated nozzle  
5 (12) extending forwardly into a well (14) in a cooled mold (18) in alignment with a gate (90) leading to a cavity (92) with an insulative air space (62) extending between the at least one heated nozzle (12) and the surrounding cooled mold (18), the at least one heated nozzle (12) having a rear end (42), a front end (76), at least a portion (94) adjacent the front end (76) with a  
10 generally cylindrical outer surface (96), and a melt bore (54) extending forwardly therethrough from the rear end (42), and an insert (70) extending forwardly from a recessed seat in the front end (76) of the at least one heated nozzle (12), the insert (70) having a rear end (78) and a melt bore (82) extending forwardly therethrough from an inlet (87) at the rear end (78)  
15 aligned with the melt bore (54) through the at least one heated nozzle (12), the improvement further comprising;

a mounting sleeve (98) integrally mounted around the cylindrical outer surface (96) of the portion (94) adjacent the front end (76) of the at least one heated nozzle (12), the mounting sleeve (98) having a threaded outer  
20 surface (104), and

a hollow removable nozzle seal (110) having a central portion (112), a retaining portion (118) extending rearwardly from the central portion (112), and a sealing and alignment flange portion (122) extending forwardly from the central portion (112), the retaining rear portion (118) having a threaded  
25 inner surface (120) to removably screw onto the threaded outer surface (104) of the mounting sleeve (98), and the forwardly extending sealing and alignment flange portion (122) fitting into a cylindrical portion (124) of the well (14) in the mold (18) extending adjacent the gate (90) to align the front end (76) of the at least one heated nozzle (12) with the gate (90) and prevent  
30 leakage of melt into the insulative air space (62) between the at least one

heated nozzle (12) and the surrounding cooled mold (18).

2. Injection molding apparatus as claimed in claim 1 wherein the central portion (112) of the nozzle seal (110) has an outer surface (114) with an even number of facets (116) for engagement by a suitable tool.

5 3. Injection molding apparatus as claimed in claim 2 wherein the central portion (112) of the nozzle seal (110) has an opening (126) therethrough through which the insert (70) extends, the opening (126) having an inner surface (128) which fits around a matching outer surface (130) of the insert (70) to accurately locate the front end (76) of the at least  
10 one heated nozzle (12).

4. Injection molding apparatus as claimed in claim 3 wherein the insert (70) has a conical outer surface (80) extending forwardly to a front tip (72), and the melt bore (82) through the insert (70) has a central rear portion (84) and at least one front portion (86) extending diagonally from the central rear  
15 portion (84) to the conical outer surface (80).

5. Injection molding apparatus as claimed in claim 4 wherein the inner surface (128) of the opening (126) through the central portion (112) of the nozzle seal (110) and matching outer surface (130) of the insert (70) are tapered inwardly towards the front to retain the insert (70) in place in the  
20 recessed seat (74) in the front end (76) of the at least one heated nozzle (12).

6. Injection molding apparatus as claimed in claim 5 wherein the mounting sleeve (98) has a rearwardly open hole (106) to receive a thermocouple element (108).

7. In an injection molding apparatus having at least one heated nozzle  
25 (12) extending forwardly into an opening (148) in a cooled mold (18)

extending to a cavity (92) with an insulative air space (62) extending between at least one heated nozzle (12) and the surrounding cooled mold (18), the at least one heated nozzle (12) having a rear end (42), a front end (76), at least a portion (94) adjacent the front end (76) with a generally cylindrical outer surface (96), and a melt bore (54) extending forwardly therethrough from the rear end (42), the improvement further comprising;

a mounting sleeve (98) integrally mounted around the cylindrical outer surface (96) of the portion (94) adjacent the front end (76) of the at least one heated nozzle (12), the mounting sleeve (98) having a threaded outer surface (104), and

a removable nozzle seal (132) having a front end (142), a central portion (134), a hollow retaining portion (118), extending rearwardly from the central portion (134), and a sealing and locating portion (136) extending forwardly from the central portion (134), the central portion (134) and the forwardly extending sealing and locating portion (136) having a melt bore (138) extending therethrough in alignment with the melt bore (54) in the heated nozzle (12) and leading to a gate (140) at the front end (142) of the nozzle seal (132), the retaining rear portion (118) having a threaded inner surface (120) to removably screw onto the threaded outer surface (104) of the mounting sleeve (98), and the forwardly extending sealing and locating portion (136) fitting into a cylindrical opening (148) in the mold (18) extending to the cavity (92) to locate the front end (76) of the at least one heated nozzle (12) and prevent leakage of melt into the insulative air space (62) between the at least one heated nozzle (12) and the surrounding cooled mold (18).

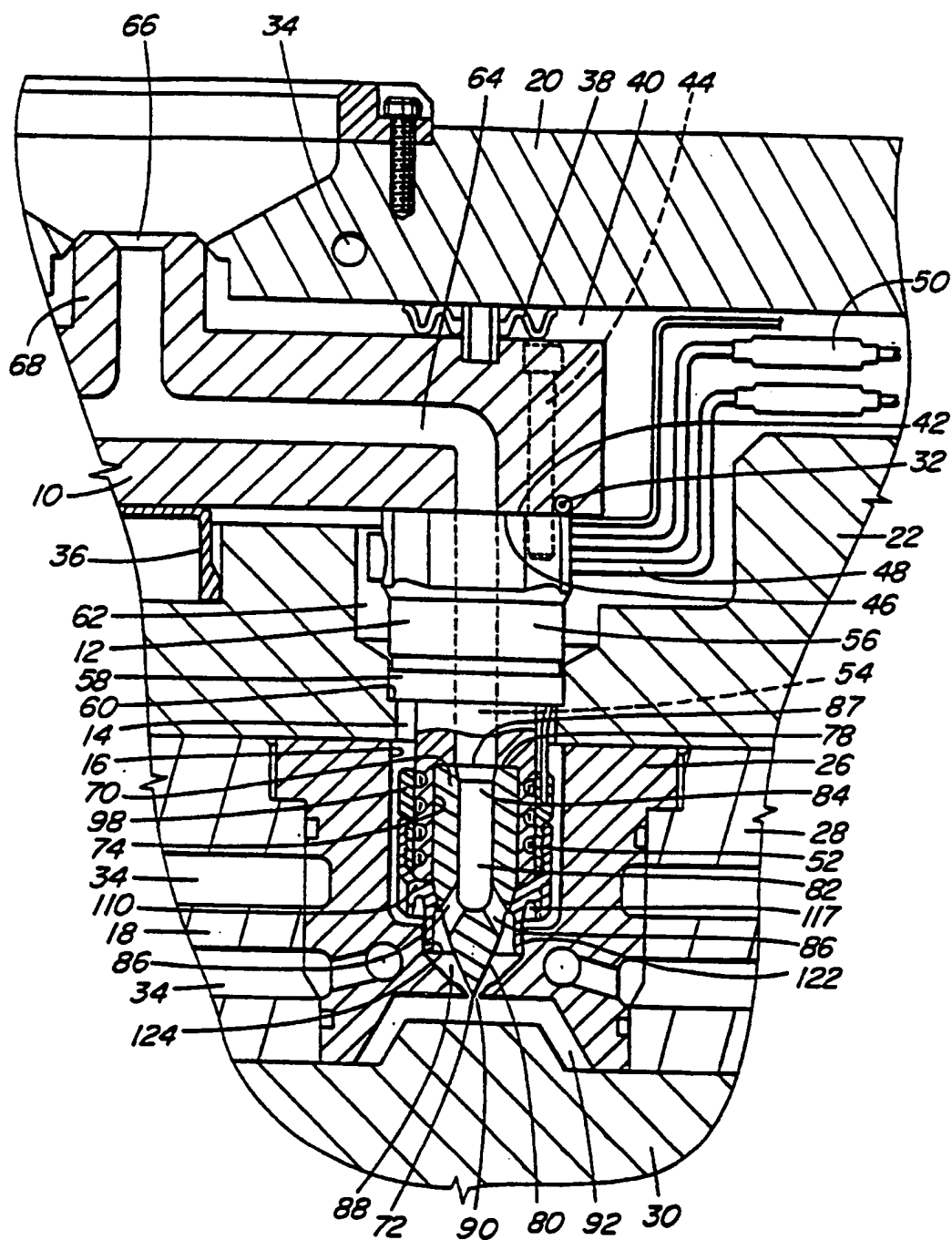
8. Injection molding apparatus as claimed in claim 7 wherein the central portion (134) of the nozzle seal (132) has an outer surface (114) with an even number of facets (116) for engagement by a suitable tool.

9. Injection molding apparatus as claimed in claim 8 wherein the

mounting sleeve (98) has a rearwardly open hole (106) to receive a thermocouple element (108).

10. A nozzle system for an injection molding apparatus comprising:
  - a heated nozzle (12) having a front end (76);
  - 5 a mounting sleeve (98) having a threaded outer surface (104) disposed on said front end (76) of the nozzle (12); and
  - a removable nozzle element (110-132) having a threaded inner surface (120) removably mounted to said mounting sleeve (98).
- 10 11. A nozzle system according to claim 10 wherein said mounting sleeve (98) includes a receptacle (106) to locate a sensor.
12. A nozzle system according to claim 10 wherein said heated nozzle includes a nozzle tip insert (70).
13. A nozzle system according to claim 12 where said removable nozzle element (110-132) has a surface (126-128) to locate and align said nozzle tip  
15 insert (70).
14. A nozzle system according to claim 10 wherein said removable nozzle element is a nozzle seal (110).
15. A nozzle system according to claim 10 where said removable nozzle element is a seal mold gate insert (132).

1/4



**FIG. 1**

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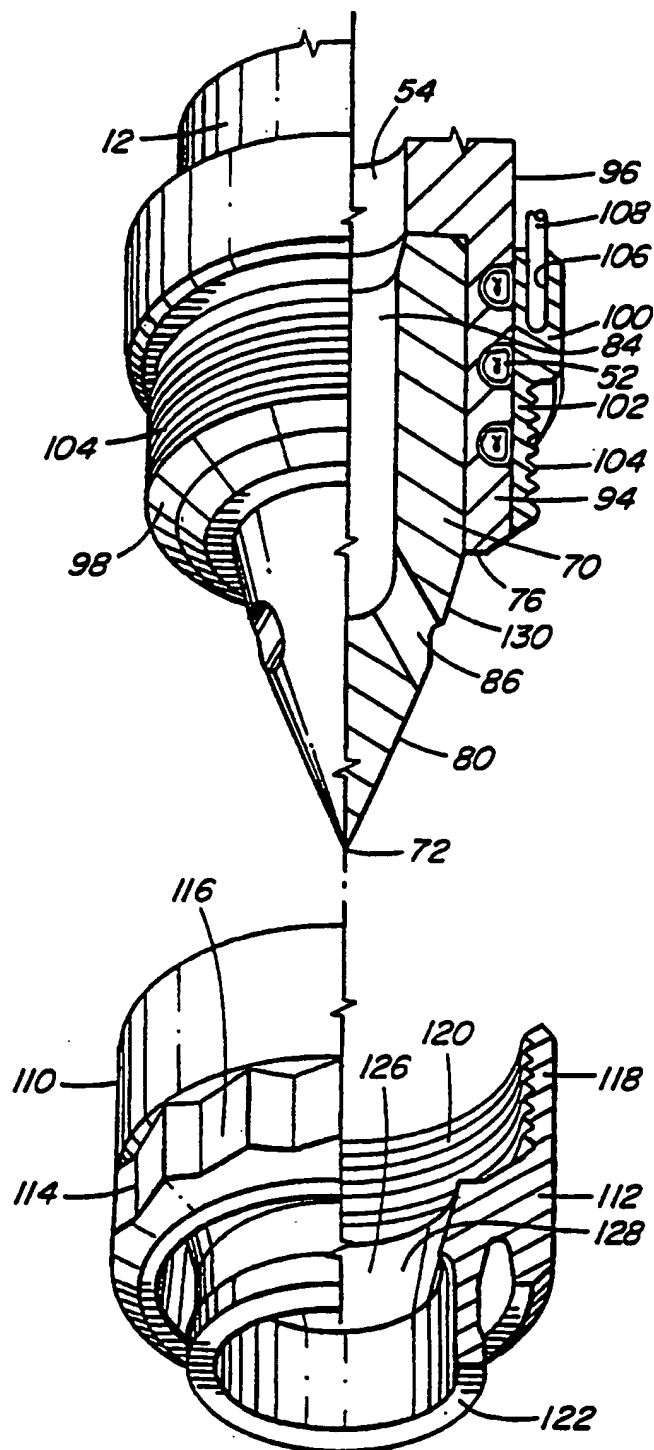


FIG. 2



3/4

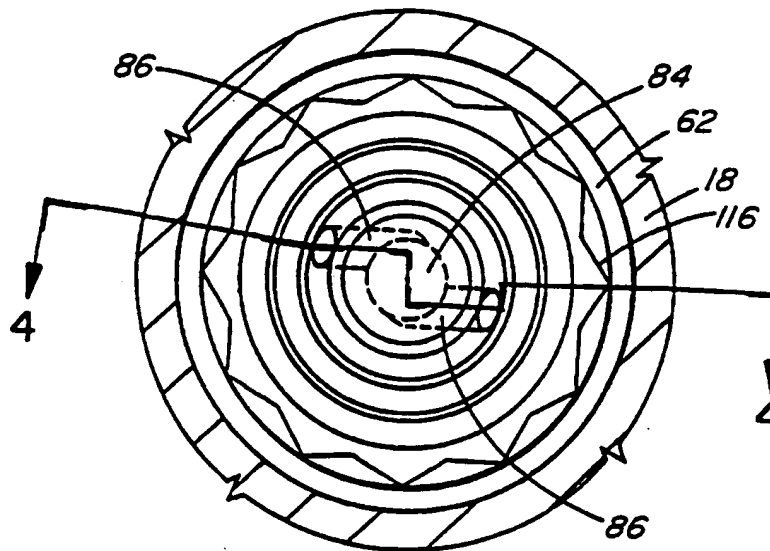


FIG. 3

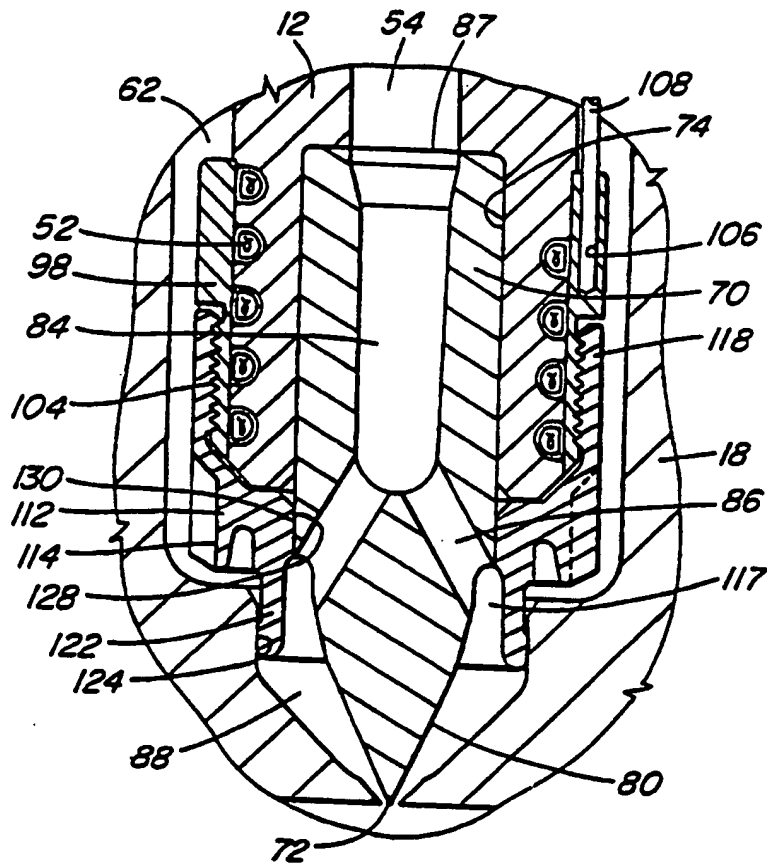


FIG. 4

4/4

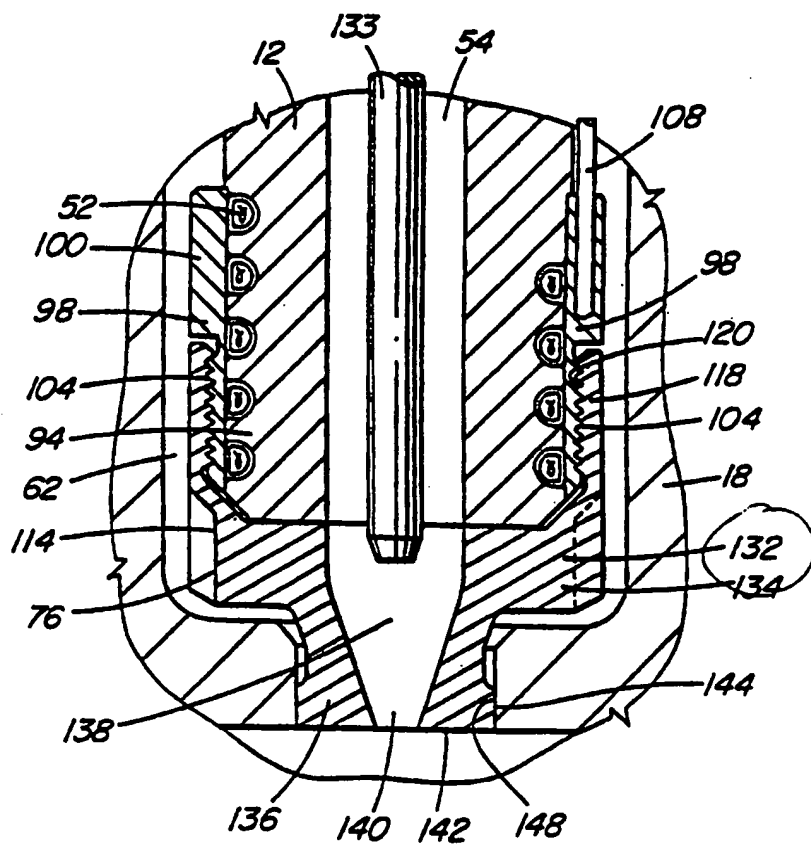


FIG. 5

# INTERNATIONAL SEARCH REPORT

International Application No.

PCT/CA 00/00142

## A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 B29C45/27

According to International Patent Classification (IPC) or to both national classification and IPC

## B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 B29C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

## C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
P, A	US 5 871 786 A (HUME WILLIAM J ET AL) 16 February 1999 (1999-02-16) the whole document	1-4, 7, 8, 10, 12-15
A	US 5 208 052 A (SCHMIDT HARALD ET AL) 4 May 1993 (1993-05-04) column 4, line 14 -column 5, line 7; figures 1, 2	1-5, 10, 12-14
A	US 4 266 723 A (OSUNA-DIAZ JESUS M) 12 May 1981 (1981-05-12) the whole document	1, 2, 7, 8, 10, 15
A	US 3 935 972 A (TSUNEMOTO SHIRO ET AL) 3 February 1976 (1976-02-03) the whole document	1, 7, 10, 15
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☒ Further documents are listed in the continuation of box C.

☒ Patent family members are listed in annex.

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Date of the actual completion of the international search

23 May 2000

Date of mailing of the international search report

30/05/2000

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Bollen, J

# INTERNATIONAL SEARCH REPORT

International Application No

PCT/CA 00/00142

## C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	NL 8 004 819 A (WAVIN BV) 1 April 1982 (1982-04-01) page 4, line 18 - line 31; figure 2 ---	1,7,10, 15
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information on patent family members

International Application No

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